

Date: Monday, 1/8/2007 10:21:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKIDTUBE ASSEMBLY
Job Number : 30103	
Estimate Number : 10022	
P.O. Number : N/A	Part Number : D205634011
This Issue : 1/8/2007	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : N/A
Previous Run : 30102	Material : N/A
Written By : <u>JA</u>	Due Date : 1/30/2007
Checked & Approved By : <u>JA 07.01.08</u>	Qty: 1 Um: Each
Comment : Est Rev:P 020828 Removed QC5 from Step 5 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

KT 07.01.31

2.0	30103A	SKID TUBE ASSEMBLY
-----	--------	--------------------

**Comment:** Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 30103A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit

1 D205-634-041 Skidtube Assembly(ref)

B29768

B30103A

R. E. Dwyer 02/15/08

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------

**Comment:** INSPECT 100% KITS FOR COMPLETENESS

07/02/03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 07/02/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:21:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 30103

Part Number: D205634011

* Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP_D205-634-011

Location: 11

JP 01/02/130

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

01/02/14

Job Completion



U 01-02-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

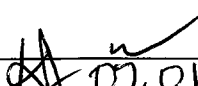
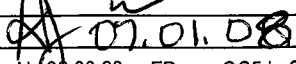
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:22:04 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 30103A
 Estimate Number : 10023
 P.O. Number : N/A Part Number : D205634041
 This Issue : 1/8/2007 S.O. No. : N/A Drawing Number : D2580 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 30102A Material : N/A
 Due Date : 1/30/2007 Qty: 1 Um: Each
 Written By : 
 Checked & Approved By : 
 Comment : Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 Est Rev. O 06.02.28 Added paperwork EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

N/A

2.0

D25001190

Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B25858

Pm/Jb 7-1-9 ①

3.0

D2596

205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B29723

Pm/Jb 7-1-11 ①

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

Pm/Jb 7-1-10 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	✓							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:22:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30103A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 102672

Sikaflex expire date: 07-02-01

Start Time: 8:00 Date: 7-1-11

Fin Time: 11:45 Date: 7-1-15 EL

Pmc JB 7-1-10 ①

Pmc JB 7-1-11 ①

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

EL *Pmc* 7-1-15

2-Cut tubes as per Dwg. D2580

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

DP 7-1-16

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 7-1-24

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3 Step *229486* *BE* 7-1-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30103A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

D2579

Crossbolt Spacer



Comment: Qty: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	B29603 BE 7-01-24

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

BE 07-01-24

2-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M102756 BE 07-01-24

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

pm 07-01-24

4-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Debur

pm 07-01-24

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

pm 07-01-24

6-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Debur

pm 07-01-24

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

pm 07-01-24

8-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M102756 BE 07-01-24

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1/07/01/29

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/07/01/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30103A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



M103141



①

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M-B/YL

07/02/08

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m

07/02/09

15.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B29488

16.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B29326

17.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	B28639

18.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	M102475

a.m 07/02/09 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30103A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

19.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	M102832

20.0	AN34A	Bolt
------	-------	------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	M100857

21.0	D25941	Plug
------	--------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: M29490

22.0	D25943	O-Ring
------	--------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B27168

23.0	D2855	Cap
------	-------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: D27488

24.0	AN35A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M15205

a.m 07/02/09 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/02/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:22:05 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30103A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M102217

a.m 07/02/09 ①

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M102672

Sikaflex expire date: 02/07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M102672

Sikaflex expire date: 02/07

a.m 07/02/09 ①

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M103004

Batch:

a.m 07/02/09 ①

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev: PPP 30103

07/02/13 ①

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/14 ①

11 07.02.14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
CP 00.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DEO 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30103A

DETAIL B
SCALE 5:24

H00.08.78
UP 08.08.78

D2576-3

GRIND FLUSH (4 PLACES)

GRIND FLUSH

STEP

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

1/4

Technical drawing showing a detail of a bolted connection. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- #0.208
- SEAL WITH SIKAFLEX--241
- AN3-4A BOLT (1)
- AN960J10L WASHER (1)
- (2 PLACES)
- D2575 CAP
- 0.40

Diagram illustrating the assembly of the D2579 Spacer. The assembly consists of a central web (D2596) and a flange (D2579). The flange has a central hole and four outer holes. The web is inserted into the central hole of the flange. The assembly is secured by a nut and washer on the opposite side of the flange.

Labels and dimensions:

- D2579 SPACER
- D2596 WEB (REF)
- ALSY-1032-130 (REF) (TYP 44 PLACES)
- 5

INSTRUCTIONS:

AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 40,508 HOLES ONLY:

1. CHAMFER HOLE $0.050 \times 45^\circ$
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437 \times 1.00$ DEEP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

Diagram showing the elevation view of the bridge deck. Key dimensions and labels include:

- 37.50 (Total deck width)
- DISTANCE TO AFT END OF D2596 WEB
- 3 (Left side of deck)
- 7 (Right side of deck)
- 1.750 (Distance from centerline to edge of deck)
- 1.750 (Distance from centerline to edge of deck)
- 0.508 (TYP.) (40 PLACES) (Distance from centerline to edge of deck)
- REFER TO DETAIL A
- 8.750 (Distance from centerline to edge of deck)
- 17.375 (Distance from centerline to edge of deck)
- 26.000 (Distance from centerline to edge of deck)
- 34.188 (Distance from centerline to edge of deck)
- 57.313 (REF) 7 EQUAL SPACES 8.188 PITCH (Distance from centerline to edge of deck)
- 38.0 (Distance from centerline to edge of deck)
- 91.500 (Distance from centerline to edge of deck)
- 190.0 (D2500-1) (Distance from centerline to edge of deck)

Diagram illustrating a horizontal curve with two tangent points. The curve is defined by a radius of 20.0 and a central angle of 4 degrees. The distance between the two tangent points is 1.0. The curve is labeled with a grade of #0.640. The distance from the start of the curve to the first tangent point is 13.4, and the distance from the second tangent point to the end of the curve is 32.0. The vertical offset at the start of the curve is 1.4.

WELD AS PER DETAIL 8

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 1.5 1.5 1.5 1.5 1.5

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

REFER TO DETAIL C

D2577-3

8

D2577-5

D2577-1

AN3-4A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)

DESIGN	DRAWN BY

PART


WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP
TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE

AN3-4A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)

RELEASED
98/09/17 DS

DESIGN <i>DH</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED <i>DH</i>	APPROVED <i>JS</i>	
DATE 98.08.26	DRAWING NO. D2580	REV. C SHEET 2 OF 2
	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

NO. 90

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 1205 634041 / B32102 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into NA Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/01/17 Qualifier David David

Jason Murdoch

From: Bill Beckett [bbeckett@dartaero.com]
Sent: Monday, February 05, 2007 1:10 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: sikaflex-291

Jason,
Yes.
Bill

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: February 5, 2007 12:49 PM
To: 'Bill Beckett'
Subject: sikaflex-291

Bill,
We have 25 tubes of sikaflex-291, batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com
Q.C. COORDINATOR